

Work Order ID 151184

September 13, 2016 3:05:14 PM

151184

Page 1

Ship Oct 20

Item ID: D212-725-1-219F

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Arc Seal Retainer

Stop ***NS2***

Start Date: 9/12/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/17/2016 Req'd Qty: 2.00

2

Customer:

Reference:

*SEP 13 2016*Approvals: Process Plan: *SK* Date: _____ Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4258	B
-------	---

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: BProg Rev: B

2-Deburr if necessary

*(2)**De 116/09/15*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

*(2)**De 116/09/15*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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Page 2

Stop *NR2*

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

Memo

Quality Control

SEP 15 2016

0.00

0.00

Memo

Packaging

FLAT PATTERN ONLY

~~SEP 19 2016~~

0.00

0.00

Memo

Quality Control

SEP 20 2016

SEP 19 2016

DAS
21
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : _____			

Picklist Print

September 13, 2016 3:05:14 PM

Page 1
1

Work Order ID: 151184

151184

Parent Item: D212-725-1-219F

D212-725-1-219F

Parent Item Name: Arc Seal Retainer

Start Date: 9/12/2016

Required Date: 10/17/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.07.21 new issue EC verified by:DD
16.04.21 material chg as per PAR16-482 DD verf:jlmm

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S24GA		Purchased		No			sf	75.2490		0.656842			
M304S24GA									**				
304/316 .025 Sheet												09/15	

Location

Loc Qty

Loc Code

MAT020

64

m135275

64

MAT20

11.249

m134677

11.249

1.9

DQA: _____ Date: _____



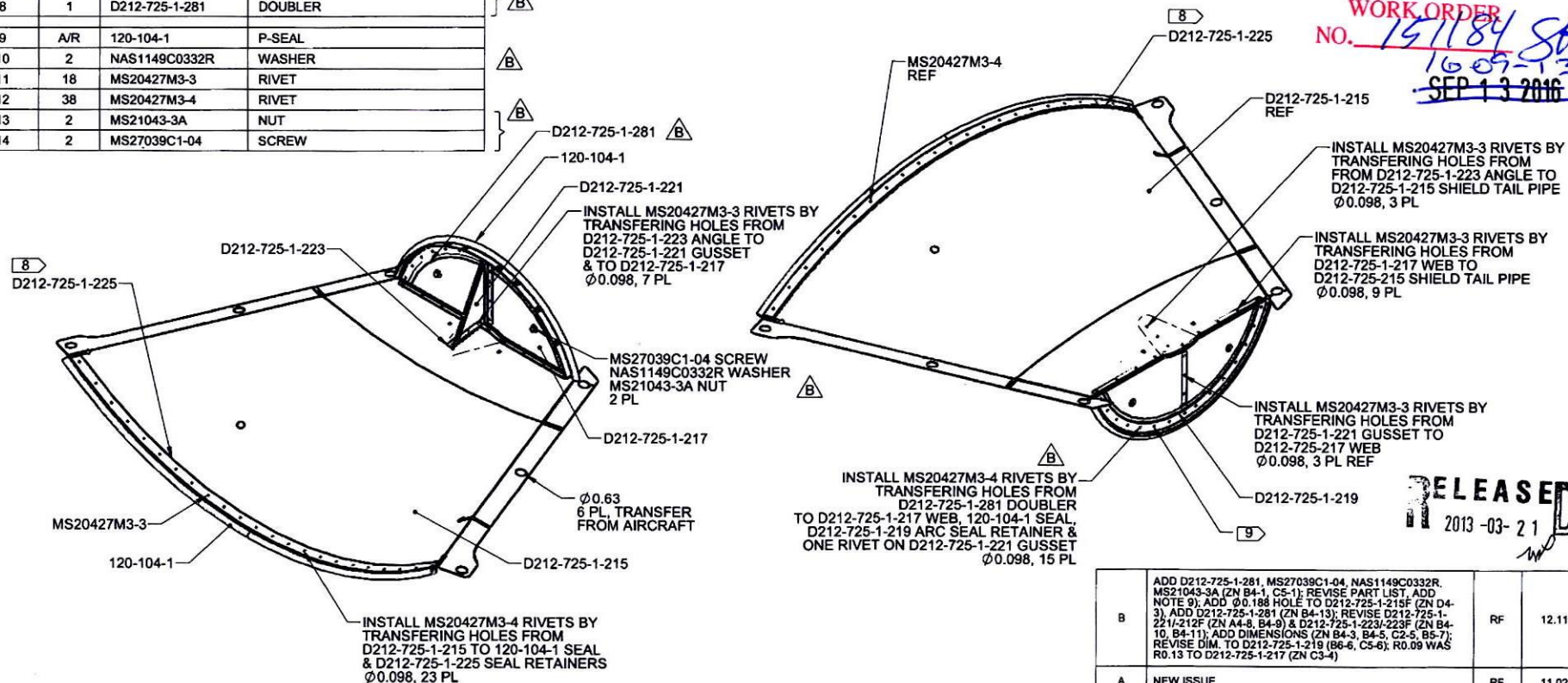
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D212-725-1-939	SHIELD TAIL PIPE ASSEMBLY
2	1	D212-725-1-215	SHIELD TAIL PIPE
3	1	D212-725-1-217	WEB
4	1	D212-725-1-219	ARC SEAL RETAINER
5	1	D212-725-1-221	GUSSET
6	1	D212-725-1-223	ANGLE
7	2	D212-725-1-225	SEAL RETAINER
8	1	D212-725-1-281	DOUBLER
9	A/R	120-104-1	P-SEAL
10	2	NAS1149C0332R	WASHER
11	18	MS20427M3-3	RIVET
12	38	MS20427M3-4	RIVET
13	2	MS21043-3A	NUT
14	2	MS27039C1-04	SCREW



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.06 lbs
- 8) TRIM TO FIT D212-725-1-215 PROFILE
- 9) RIVET 1.25 PITCH ON THIS SIDE

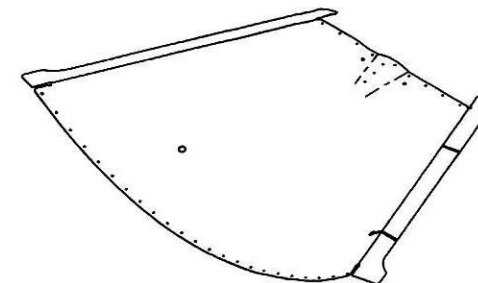
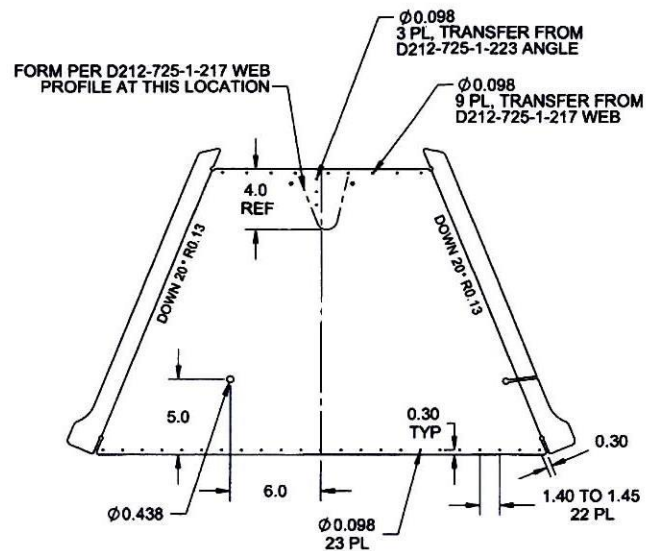
D212-725-1-939 SHIELD TAIL PIPE ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 151184 SH
1605-13
SEP 13 2016

RELEASED
2013-03-21

B	ADD D212-725-1-281, MS27039C1-04, NAS1149C0332R, MS21043-3A (ZN B4-1, C5-1); REVISE PART LIST, ADD NOTE 9; ADD $\phi 0.188$ HOLE TO D212-725-1-215F (ZN D4-3); ADD D212-725-1-281 (ZN B4-13); REVISE D212-725-1-221F (ZN A4-8, B4-9) & D212-725-1-223F (ZN B4-10, B4-11); ADD DIMENSIONS (ZN B4-3, B4-5, C2-5, B5-7); REVISE DIM. TO D212-725-1-219 (B6-6, C5-6); R0.09 WAS R0.13 TO D212-725-1-217 (ZN C3-4)	RF	12.11.15
A	NEW ISSUE	RF	11.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	12.11.15		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4258 TITLE SHIELD TAIL PIPE ASSEMBLY SCALE NTS COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



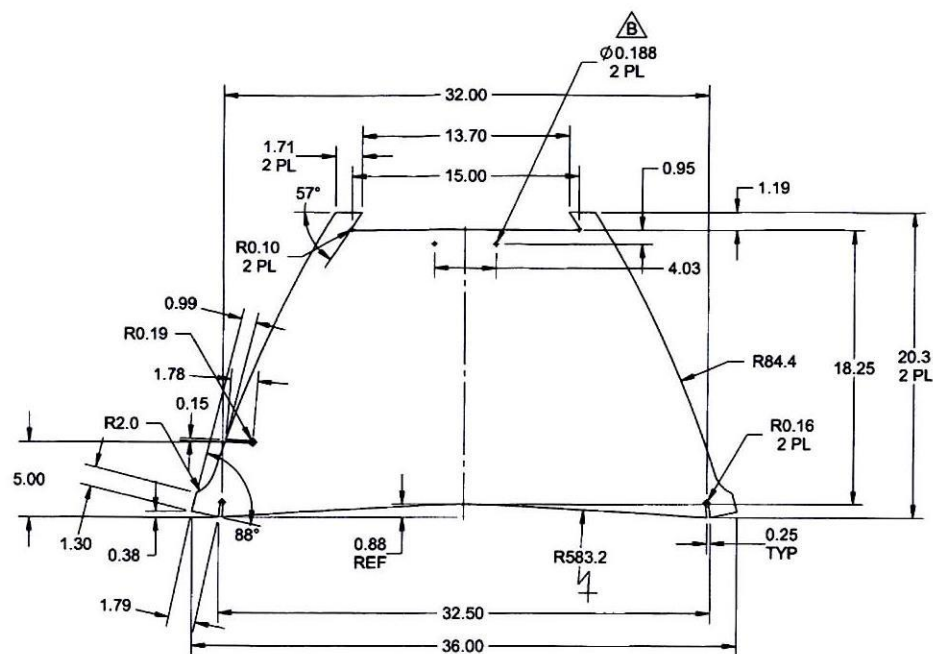
D212-725-1-215 SHIELD TAIL PIPE
(MAKE FROM D212-725-1-215F FLAT PATTERN)

NOTES:

- 1) MATERIAL: MAKE FROM D212-725-1-215F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.00 lbs

RELEASED
2013-03-21

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4258	SHEET 2 OF 13
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SHIELD TAIL PIPE ASSEMBLY	NTS
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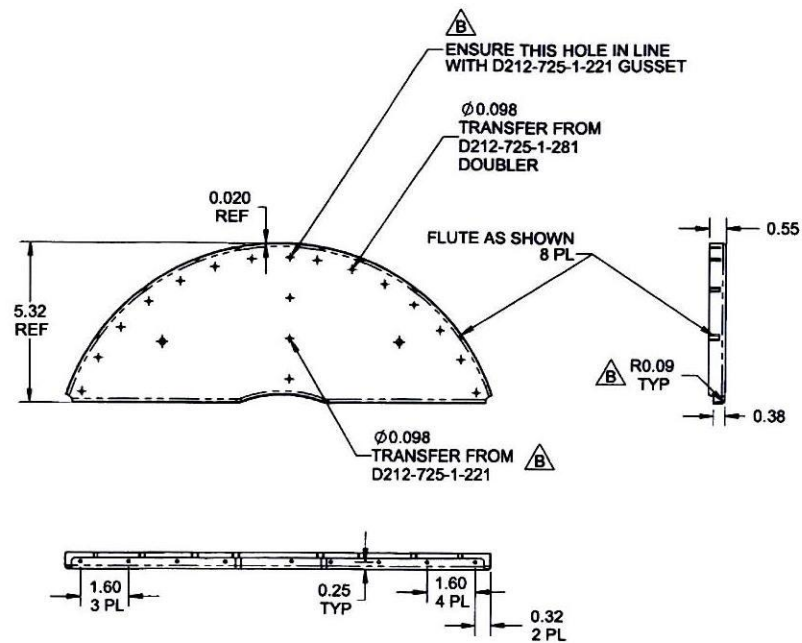
D212-725-1-215F FLAT PATTERN B

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 (25 GAUGE) THICK
 ANNEALED
 2B FINISH
 PER MIL-S-5059
 OR AMS-5513 (304)
 OR AMS 5524 (316)
 OR ASTM A240
 OR ASME SA240
 REF DART SPEC. M304S25GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.00 lbs

RELEASED
 2013-03-21
MP

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D4258	REV. B
MFG. APPR.	<i>RF</i>	SHEET 3 OF 13	
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	SHIELD TAIL PIPE ASSEMBLY	NTS
DATE	12.11.15	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



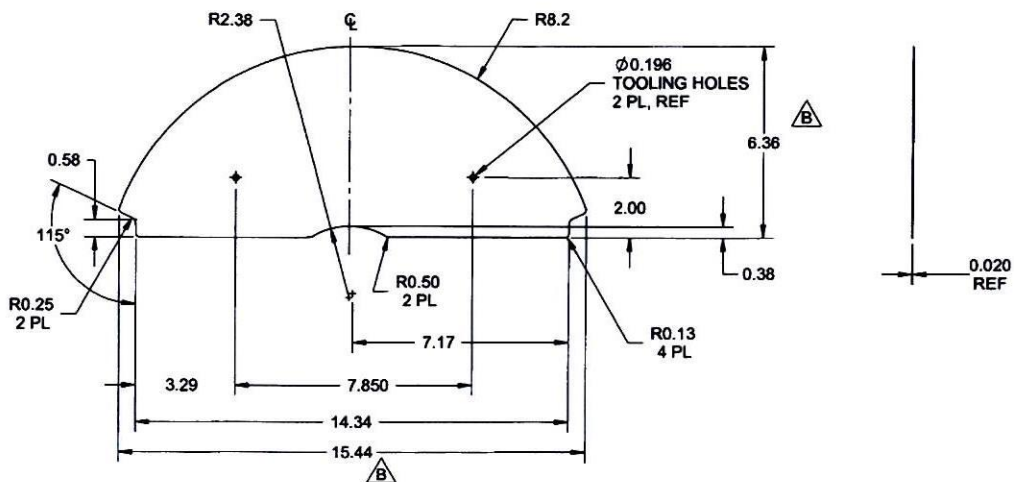
D212-725-1-217 WEB
(MAKE FROM D212-725-1-217F FLAT PATTERN)

NOTES:

- 1) MATERIAL: MAKE FROM D212-725-1-217F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.43 lbs

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2013-03-21
WIP

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D4258	REV. B
MFG. APPR.	<i>RF</i>	SHEET 4 OF 13	
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	SHIELD TAIL PIPE ASSEMBLY	NTS
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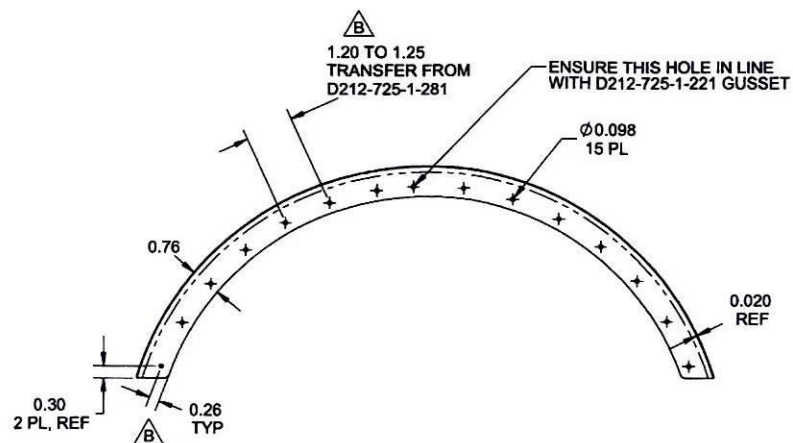
D212-725-1-217F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 (25 GAUGE) THICK
ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS-5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S25GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.43 lbs

RELEASED
2013-03-21

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4258	REV. B
MFG. APPR.		SHEET 5 OF 13	
APPROVED		TITLE	SCALE
DE APPR.		SHIELD TAIL PIPE ASSEMBLY	
DATE	12.11.15	NTS	
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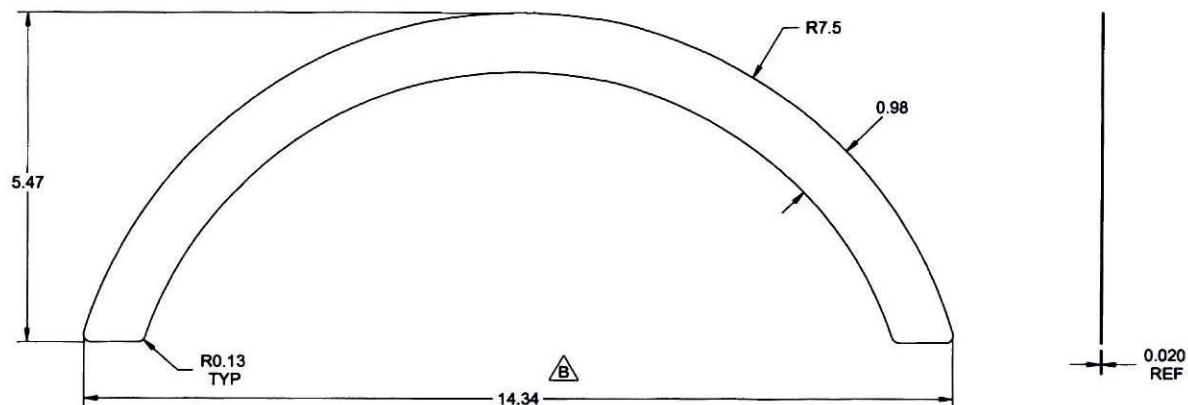


D212-725-1-219 ARC SEAL RETAINER
(MAKE FROM D212-725-1-219F FLAT PATTERN)

NOTES:

- 1) MATERIAL: MAKE FROM D212-725-1-219F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4258	REV. B
MFG. APPR.	RF	SHEET 6 OF 13	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SHIELD TAIL PIPE ASSEMBLY	NTS
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D212-725-1-219F FLAT PATTERN

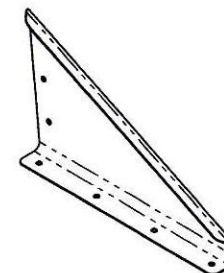
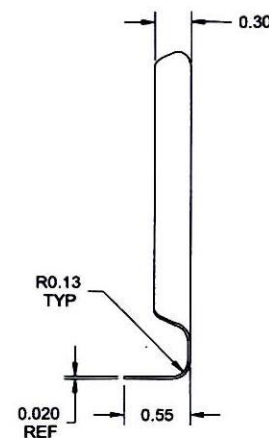
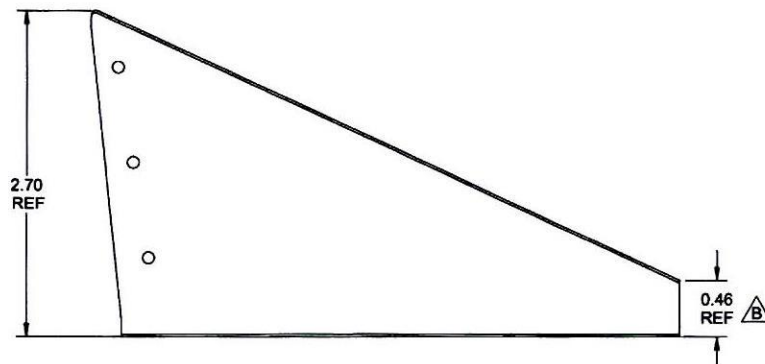
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 (25 GAUGE) THICK
ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS-5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S25GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4258	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 7 OF 13	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHIELD TAIL PIPE ASSEMBLY	
DATE	12.11.15	NTS	

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2013-03-21
[Signature]



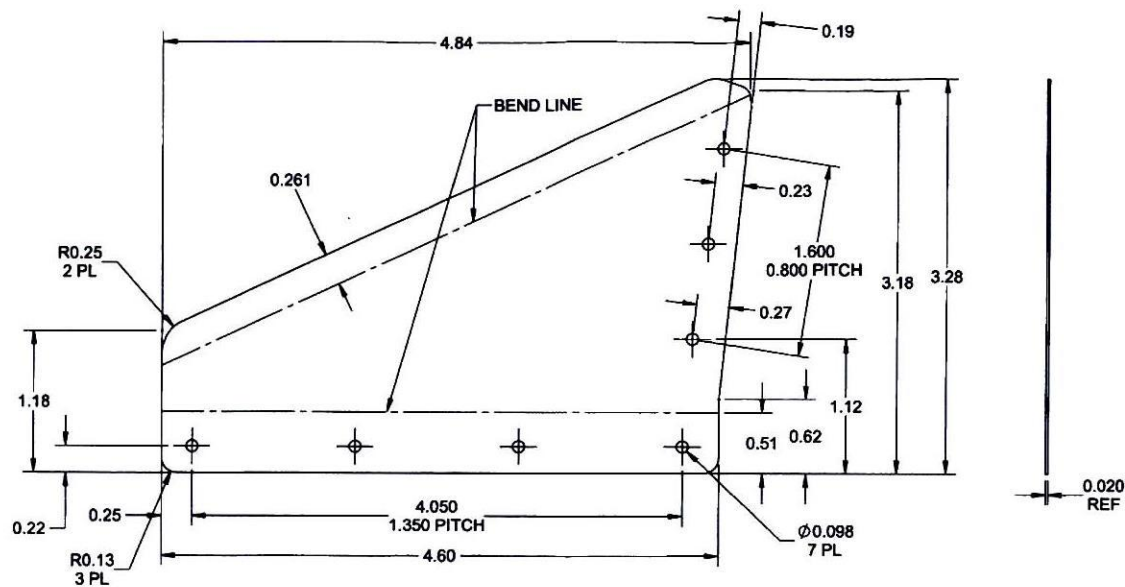
D212-725-1-221 GUSSET
(MAKE FROM D212-725-1-221F FLAT PATTERN)

NOTES:

- 1) MATERIAL: MAKE FROM D212-725-1-221F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

RELEASED
2013-03-21

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JS</i>	D4258	SHEET 8 OF 11
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	SHIELD TAIL PIPE ASSEMBLY	NTS
DATE	12.11.15	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



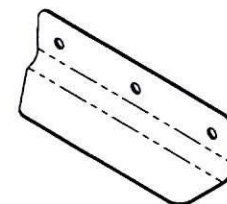
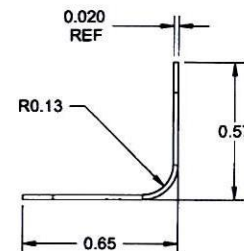
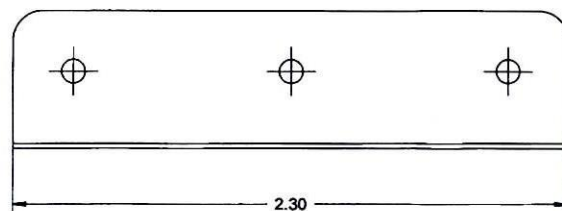
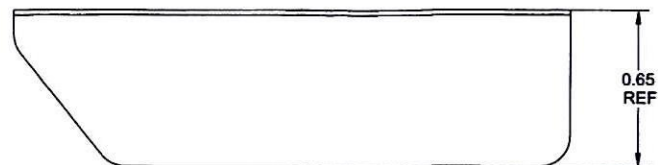
D212-725-1-221F FLAT PATTERN B

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 (25 GAUGE) THICK
 ANNEALED
 2B FINISH
 PER MIL-S-5059
 OR AMS-5513 (304)
 OR AMS 5524 (316)
 OR ASTM A240
 OR ASME SA240
 REF DART SPEC. M304S25GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs

RELEASED
 2013-03-21
 JMD

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D4258	REV. B
MFG. APPR.		SHEET 9 OF 13	
APPROVED		TITLE	SCALE
DE APPR.		SHIELD TAIL PIPE ASSEMBLY NTS	
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D212-725-1-223 ANGLE
(MAKE FROM D212-725-1-223F FLAT PATTERN)

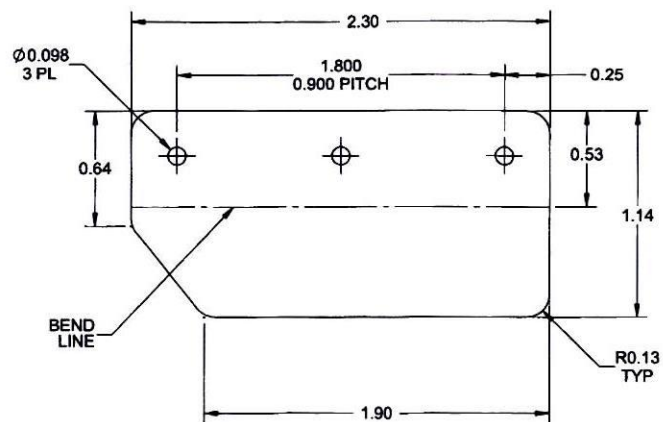


NOTES:

- 1) MATERIAL: MAKE FROM D212-725-1-223F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

RELEASE
2013-03-21

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4258	SHEET 10 OF 13
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SHIELD TAIL PIPE ASSEMBLY	NTS
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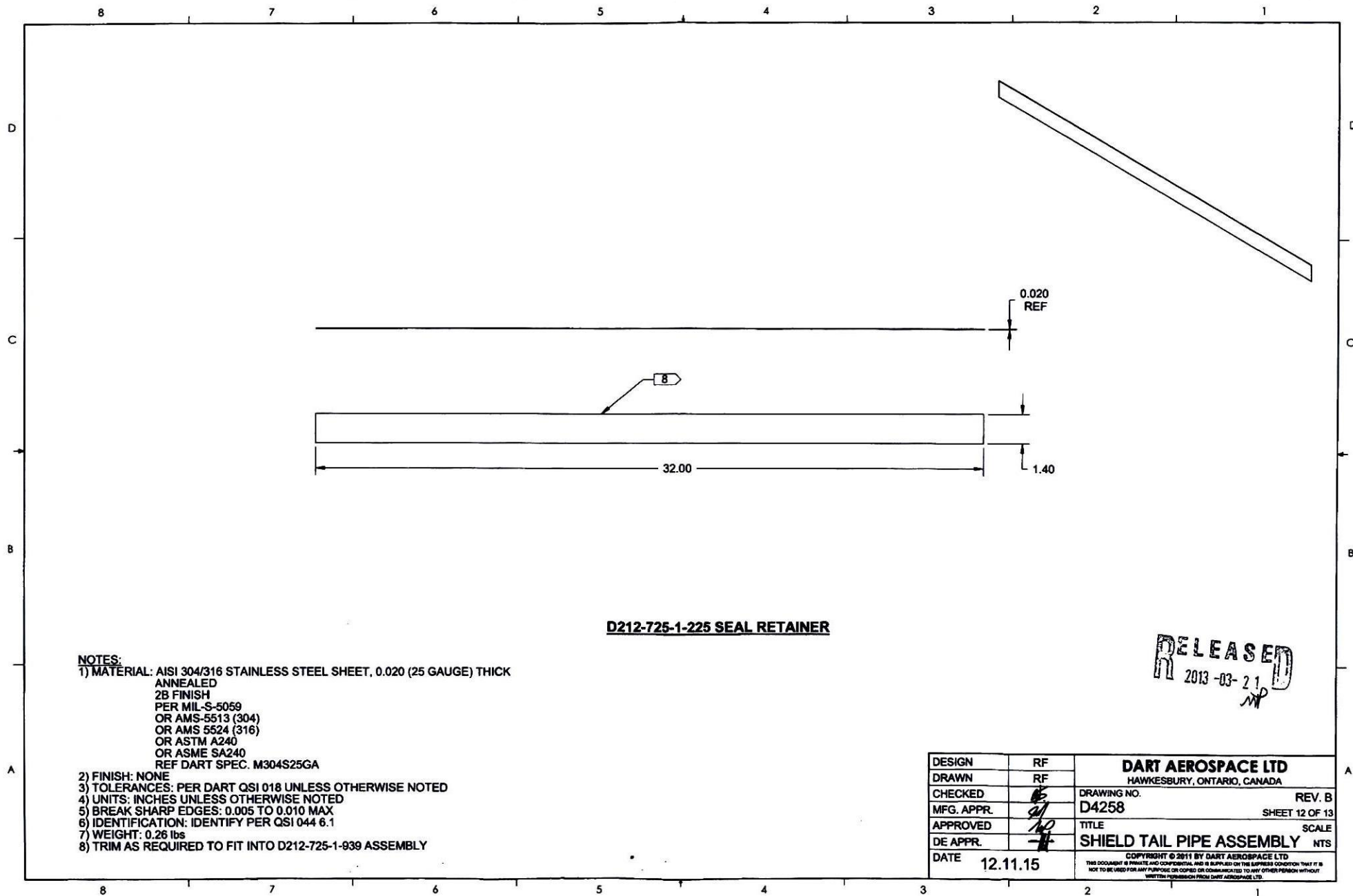
D212-725-1-223F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 (25 GAUGE) THICK
 ANNEALED
 2B FINISH
 PER MIL-S-5059
 OR AMS-5513 (304)
 OR AMS 5524 (316)
 OR ASTM A240
 OR ASME SA240
 REF DART SPEC. M304S25GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

RELEASED
 2013-03-21

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D4258	REV. B
MFG. APPR.		SHEET 11 OF 13	
APPROVED		TITLE	SCALE
DE APPR.		SHIELD TAIL PIPE ASSEMBLY	NTS
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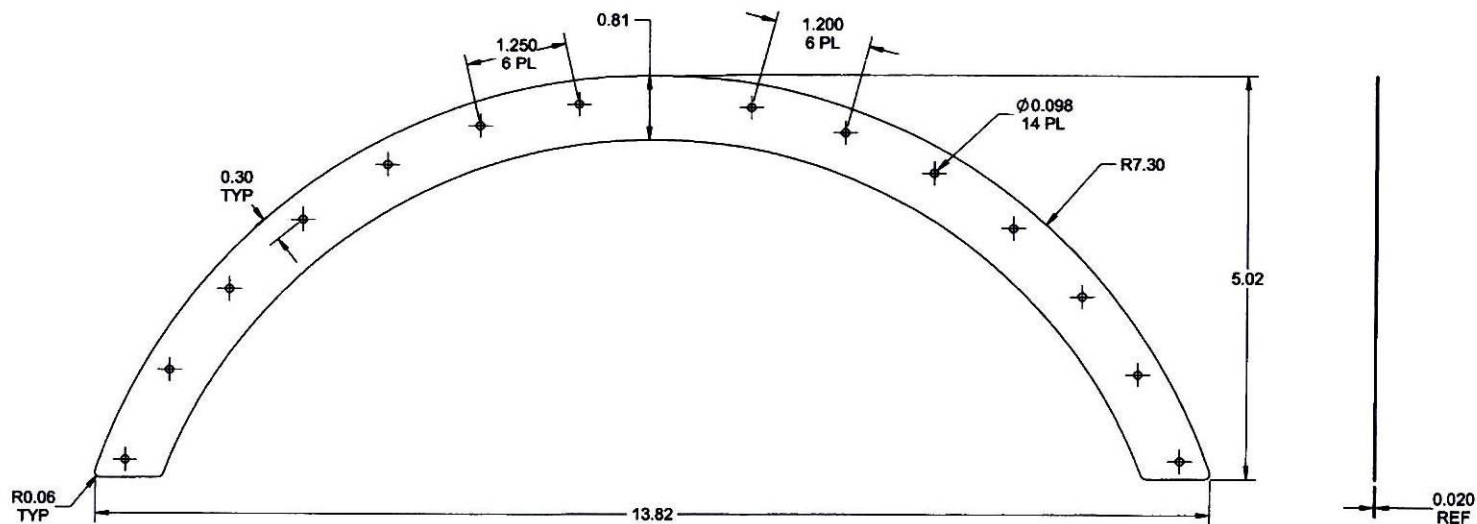
D212-725-1-225 SEAL RETAINER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 (25 GAUGE) THICK
ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS-5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S25GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.26 lbs
- 8) TRIM AS REQUIRED TO FIT INTO D212-725-1-939 ASSEMBLY

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2013-03-21
MP

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4258	SHEET 12 OF 13
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SHIELD TAIL PIPE ASSEMBLY	NTS
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D212-725-1-281 DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 (25 GAUGE) THICK
ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS-5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S25GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.08 lbs
- 8) TRIM AS REQUIRED TO FIT INTO D212-725-1-217 WEB

RELEASED
2013-03-21

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4258	SHEET 13 OF 13
APPROVED		TITLE	SCALE
DE APPR.		SHIELD TAIL PIPE ASSEMBLY	NTS
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